

Date: Thursday, 6/21/2007 2:29:25 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEB
Job Number	33062	Part Number	D2739
Estimate Number	10498	Drawing Number	D2739 REV C
P.O. Number	N/A	Project Number	N/A
This Issue	6/21/2007	Type	LANDING GEAR
Prsht Rev.	NC	Drawing Revision	C
First Issue	N/A	Material	N/A
Previous Run	32989	Due Date	7/10/2007
Written By		Qty:	8
Checked & Approved By	907-06-22	Um:	Each
Comment	Est Rev: C 02.11.28 Rerformat KJ		
	Est Rev: D 06-03-21 As Per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D26005108	Extrusion 'I Beam' thin
Comment: Qty: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) Extrusion 'I Beam' thin Pick: Qty Part Number Description Batch 1 D2600-5 Web B29785		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. 5-Dburr		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 09/07/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 33062		Part Number: D2739
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
6.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION  7-7-10		
Comment: PACKAGING RESOURCE #1 Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.		
Identify and Stock Location: L6		
7.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE Do 07/11		
Job Completion		 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

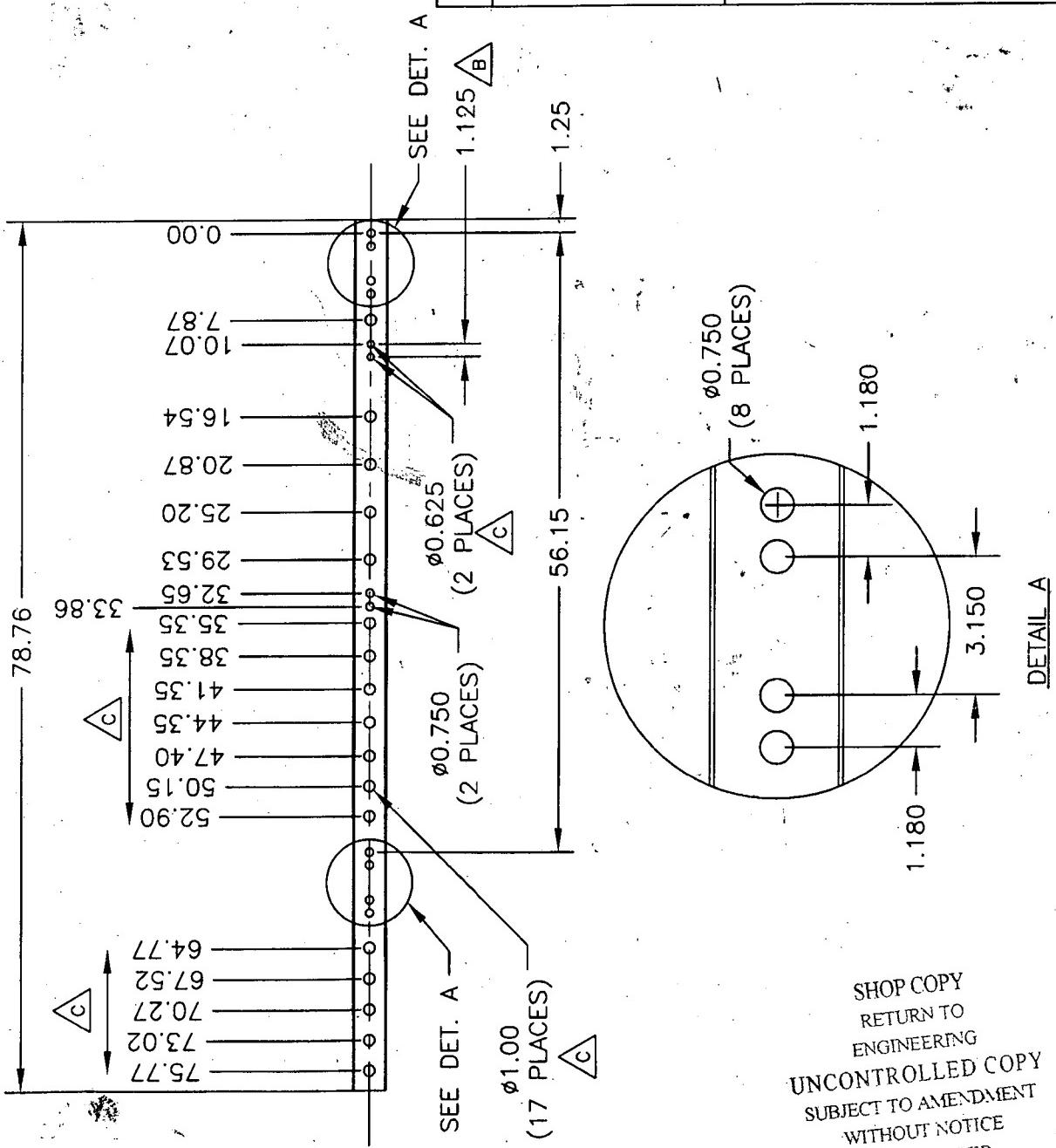
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

DART

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2739	REV. C SHEET 1 OF 1	
DATE 06.01.05		TITLE WEB	SCALE 1:15	
A	98.04.16	NEW ISSUE		
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS		
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS		



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D2739 WEB
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